



# Work Order ID 145332

Thursday, May 05, 2016 1:34:30 PM

**\*145332\***

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Item ID: D119-796-251 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: AFT Crosstube Installation with Step (no hardware)  
 Start Date: 5/16/2016 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/20/2016 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp    |
|--------------------------------|--------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 140                            | QC5- Inspect part completeness to step on W/O          | 0.00                 |         |        |              |               |               |                  | DAS<br>9<br>9-89  |
| <b>*140*</b>                   |                                                        |                      |         |        |              |               |               |                  |                   |
| QC                             | Memo                                                   | 0.02                 |         |        |              |               |               |                  |                   |
| Quality Control                | ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***            |                      |         |        |              |               |               |                  |                   |
|                                | ***VERIFY BY <u>DAS</u> BATCH # TO MATCH W/O           |                      |         |        |              |               |               |                  |                   |
|                                | ***VERIFY BY <u>9</u> PART # TO MATCH                  |                      |         |        |              |               |               |                  |                   |
|                                | W/O <u>3-89</u>                                        |                      |         |        |              |               |               |                  |                   |
| 150                            | Packaging                                              | 0.00                 |         |        |              |               |               |                  | DAS<br>41<br>9-89 |
| <b>*150*</b>                   |                                                        |                      |         |        |              |               |               |                  |                   |
| Packaging                      | Memo                                                   | 0.00                 |         |        |              |               |               |                  |                   |
| Packaging                      | Identify and pack for shipping as per PPP D119-796-251 |                      |         |        |              |               |               |                  | 16-8-3            |
|                                | "Au1"                                                  |                      |         |        |              |               |               |                  |                   |
| 160                            | QC21- Final Inspection - Work Order Release            | 0.00                 |         |        |              |               |               |                  | DAS<br>21<br>9-89 |
| <b>*160*</b>                   |                                                        |                      |         |        |              |               |               |                  |                   |
| QC                             | Memo                                                   | 0.10                 |         |        |              |               |               |                  |                   |
| Quality Control                |                                                        |                      |         |        |              |               |               |                  |                   |

DAS  
21  
9-89  
AUG 04 2016

# Picklist Print

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Work Order ID: 145332

**\*145332\***

Parent Item: D119-796-251

**\*D119-796-251\***

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/16/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B  
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19  
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER  
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D  
JLM VERF:DD

| Component Item ID/<br>Item Name                       | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued    | Status |
|-------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|-------------------|--------|
| D119-796-241                                          |                        | Manufactured  | No          |                     |                  |                 | Each               | 0.0000         |             | 1            |               | DAS<br>41<br>9-89 |        |
| <b>*D119-796-241*</b>                                 |                        |               |             |                     | 145282           |                 |                    |                | **          | 1            |               | 16-7-19           |        |
| AFT Crosstube Installation without Step (no hardware) |                        |               |             |                     |                  |                 |                    |                |             |              |               |                   |        |
| D5123-3                                               |                        | Manufactured  | No          |                     |                  |                 | Each               | 64.0000        |             | 4            |               | DAS<br>41<br>9-89 |        |
| <b>*D5123-3*</b>                                      |                        |               |             |                     |                  |                 |                    |                | **          |              |               | 16-7-19           |        |
| Clamp Cushion                                         |                        |               |             |                     |                  |                 |                    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | 145854           |                 |                    |                |             | 4            |               |                   |        |
|                                                       |                        |               |             |                     | <u>Location</u>  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | LG055            | 64              |                    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | 141331           | 8               |                    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | 144626           | 56              |                    |                |             |              |               |                   |        |
| D5149-043                                             |                        | Manufactured  | No          |                     |                  |                 | Each               | 6.0000         |             | 2            |               | DAS<br>41<br>9-89 |        |
| <b>*D5149-043*</b>                                    |                        |               |             |                     |                  |                 |                    |                | **          |              |               | 16-8-3            |        |
| Aft Step Base Assembly                                |                        |               |             |                     |                  |                 |                    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | 149108           |                 |                    |                |             | 2            |               |                   |        |
|                                                       |                        |               |             |                     | <u>Location</u>  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | LG055            | 6               |                    |                |             |              |               |                   |        |
|                                                       |                        |               |             |                     | 142591           | 6               |                    |                |             |              |               |                   |        |

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**\*145332\***

Parent Item: D119-796-251

**\*D119-796-251\***

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 5/16/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

32.0000

4

DAS

41

9-89

16-7-19

**\*MS21920-25\***

**\*\***

Clamp

#5 -> 1 scrap

Location

Loc Qty

Loc Code

FG

10

120920

10

LG050

14

m134588

14

LG057

8

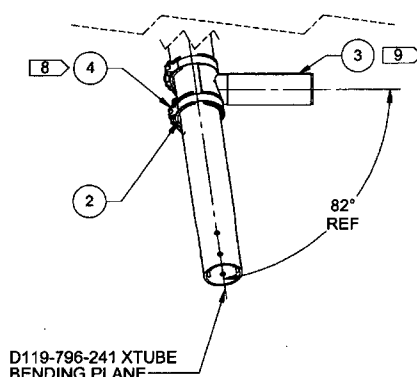
m134507

8

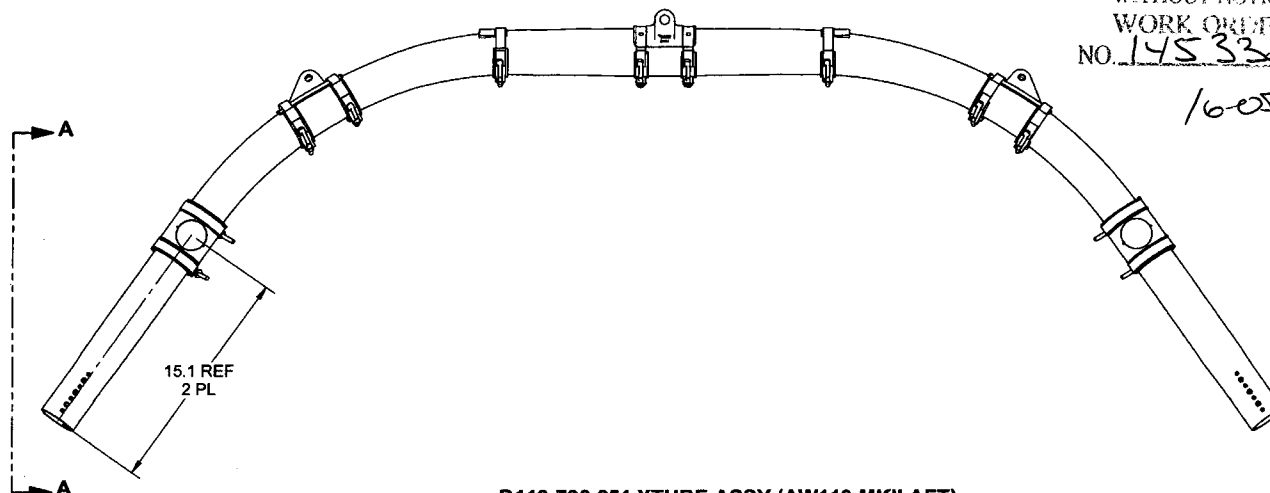
| ITEM | QTY | P/N          | DESCRIPTION                 |
|------|-----|--------------|-----------------------------|
|      | X   | D119-796-251 | XTUBE ASSY (AW119 MKII AFT) |
| 1    | 1   | D119-796-241 | XTUBE ASSY (AW119 MKII AFT) |
| 2    | 4   | D5123-3      | CUSHION                     |
| 3    | 2   | D5149-043    | AFT STEP ASSY               |
| 4    | 4   | MS21920-25   | CLAMP                       |

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 145332 M/S

1605-06



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

| D          | D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED      | AP                                                                                                                                                                                                                                                                       | 15.01.19     |
|------------|-----------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| C          | RE-DESIGN STEP INSTALLATION                         | DB                                                                                                                                                                                                                                                                       | 14.11.24     |
| B          | D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A | AP                                                                                                                                                                                                                                                                       | 14.10.04     |
| A          | NEW ISSUE                                           | AP                                                                                                                                                                                                                                                                       | 14.08.03     |
| REV.       | DESCRIPTION                                         | BY                                                                                                                                                                                                                                                                       | DATE         |
| DESIGN     | AP                                                  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                        |              |
| DRAWN      | AP                                                  |                                                                                                                                                                                                                                                                          |              |
| CHECKED    | DB                                                  | DRAWING NO.                                                                                                                                                                                                                                                              | REV. D       |
| MFG. APPR. | DD                                                  | D119-796-251                                                                                                                                                                                                                                                             | SHEET 1 OF 1 |
| APPROVED   | HS                                                  | TITLE                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   | DS                                                  | XTUBE ASSY (AW119 MKII AFT)                                                                                                                                                                                                                                              | NTS          |
| DATE       | 15.01.19                                            | COPYRIGHT © 2014 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

APPROVED